

To ship Dec 23

Work Order ID 133138

133138

Page 1

Tuesday, May 26, 2015 12:48:01 PM

Item ID: D412-709-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 5/22/15 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/26/15 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MJS Date: MAY 27 2015 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D412-709	Rev C

100 Document Control 0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPD412-709-011 CHG001

DAS
27
9-09

JAN 05 2016

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

DAS
28
9-89

DEC 15 2015

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Memo

0.00

Quality Control

JAN 05 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Page 2

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Revision ID:

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Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 5/22/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/26/15 Req'd Qty: 1.00 ***1***

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Run Start ***NR1***

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Stop ***NR2***

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130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-709-011								
	Location: <u>016</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

27
9-3
JAN 05 2016

ms

JAN 05 2016

SA 120160105

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																																																																		
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																																																																		
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																																																																		
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																																																																		
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																																																																		
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																																																																		
OTHER : ☐																																																																																																																					

Picklist Print

Tuesday, May 26, 2015 12:48:00 PM

Page 1

Work Order ID: 133138

133138

Parent Item: D412-709-011

D412-709-011

Parent Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 5/22/15

Required Date: 5/26/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B Removed Manufacturing 05-11-06 JLM
IPP rev C removed sub-components 07.11.12 EC IPP Rev:D
10.05.20 added D3561-1 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN6-20A BOLT		Purchased	No			110	Each	27.0000	3	3			
AN6-20A									**	132576			DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST286A				25					
				M128936				25					
				ST334				2					
				M130466				2					
D3118-3 Sign Assembly		Manufactured	No			110	Each	0.0000	1	1			
D3118-3									**	B 131395x1			DAS 28 9-89
D3224-1 Frame		Manufactured	No			110	Each	5.0000	1	1			
D3224-1									**	132532			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST441				5					
				123657				1					
				130482				4					
D3239-1 Cover		Manufactured	No			110	Each	5.0000	2	2			
D3239-1									**	133103			DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST031				5					
				131565				5					

DEC 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

Picklist Print

Tuesday, May 26, 2015 12:48:00 PM

Page 2

Work Order ID: 133138

133138

Parent Item: D412-709-011

D412-709-011

Parent Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 5/22/15

Required Date: 5/26/15

Start Qty: 1.00

Required Qty: 1.00

D412-709-013

Manufactured No

110

Each

0.0000

1

1

D412-709-013

DAS
27
8-89

**

138867

DAS
28
9-89

Escape Panel Push-Out Window Clear Fits LH or RH

MS21042L3

Purchased No

110

Each

2,435.000

2

2

MS21042L3

DAS
27
8-89

**

133790

Nut

Location

Loc Qty

Loc Code

FP001

420

M130922

420

GA

515

M131317

515

ST305

1500

116549

12

126333

49

M128754

2

M132123

437

M132382

1000

MS21042L6

Purchased No

110

Each

510.0000

3

3

MS21042L6

DAS
27
8-89

**

133483

Nut

Location

Loc Qty

Loc Code

ST260a

200

m132262

200

ST273A

200

m131624

200

ST305

1

m129909

1

t260a

109

m131317

109

DEC 15 2015

DAS
28
9-89

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Page 3

Tuesday, May 26, 2015 12:48:00 PM

Work Order ID: 133138

133138

Parent Item: D412-709-011

D412-709-011

Parent Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 5/22/15

Required Date: 5/26/15

Start Qty: 1.00

Required Qty: 1.00

MS35207-262

Purchased

No

110

Each

22.0000

2

2

MS35207-262

**

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST276

22

M131420

22

2

NAS1149D0332J

Purchased

No

110

Each

1,877.000

2

2

NAS1149D0332.J

**

Washer

133498

Location

Loc Qty

Loc Code

CA

14

m129682

14

ST269

1031

m130325

879

m131624

152

ST270

832

m132189

832

NAS1149D0616J

Purchased

No

110

Each

283.0000

5

5

NAS1149D0616.J

**

WASHER

Location

Loc Qty

Loc Code

ST269

283

122815

283

DEC 15 2015

DAS
28
9-89

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																									
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Picklist Print

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Work Order ID: 133138

133138

Parent Item: D412-709-011

D412-709-011

Parent Item Name: Escape Panel Modification Clear Fits LH or RH

Start Date: 5/22/15

Required Date: 5/26/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0663J

Purchased

No

110

Each

1,766.000

5

5

NAS1149D0663.J

133138

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

ST260

699

M131618

699

ST260a

1000

M132256

1000

ST269

67

M126334

67

DEC 15 2015

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

52.10 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-709-011	ESCAPE PANEL MODIFICATION KIT
1	X						D412-709-013	ESCAPE PANEL PUSH OUT WINDOW KIT
		X					D412-709-015	HINGE PANEL DOOR MODIFICATION KIT
		1	X				D412-709-017	HINGE PANEL DOOR REPLACEMENT WINDOW KIT
				X			D412-709-019	CARGO DOOR PUSH OUT WINDOW KIT
					X		D412-709-021	HINGE PANEL DOOR PUSH OUT WINDOW MODIFICATION KIT
					1	X	D412-709-023	HINGE PANEL DOOR REPLACEMENT PUSH OUT WINDOW KIT
			1				D2126-0720	LOCKING SEAL
1				1			D3118-3	SIGN ASSEMBLY
	1						D3136-041	WINDOW ASSEMBLY
1							D3136-043	WINDOW ASSEMBLY
			1				D3224-1	FRAME
							D3236-1	WINDOW
						1	D3237-1-0720	SEAL RETAINER
	1			1			D3237-1-0980	SEAL RETAINER
						1	D3237-3-0720	SEAL FILLER
	1			1			D3237-3-0980	SEAL FILLER
2							D3239-1	COVER
		1					D3240-1	FRAME
						1	D3543-1	HINGE PANEL DOOR PUSH OUT WINDOW
					1		D3543-3	HINGE PANEL DOOR PUSH OUT WINDOW FRAME
	1			1		1	D3561-1	WINDOW SEAL TOOL
							AN6-20A	BOLT
3							AN960JD10L	WASHER
2							AN960JD616	WASHER
5							AN960JD616L	WASHER
5							MS21042L3	NUT
2							MS21042L6	NUT
3							MS35207-262	SCREW
2								

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